Work Ordo <i>May-06-14 8:08</i>		984		*118	-7144		Page 1				
Revision ID: Item Name:	D3546-1			Accept	*N900		100)* ፡	Setup Sta	171	S1* S2*
Start Date: Required Date: Reference:		Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*		Cust Item Customer:						
Approvals:	Process Plan:	MLJ	Date: 14-05-0	1 Tooling:	D	ate:		1	Run Sta	^1 <i>\</i> J	R1*
	QC:		Date:	_ SPC (Y/N):	D			Sto	^{₀p} *N	R2*	
Sequence ID/ Work Center II		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revisi	on Nbr									-
D3546	Rev A									DAS	3
100				0.00			****			46	
100 Waterjet	F	LOW WATER JET Memo		0.00				(24)		^{.9} -89	11/80/11
FLOW CNC Waterje	et		A								
110	Q	C2- Inspect parts off m	achine FAI/FAIB	0.00				_		DAS	3
110 QC Quality Control		Memo		0.00				24)	DAS 46 - 9-89	14/08/11
120	Q	C8- Inspect parts - seco	nd check	0.00							DAS 38 9-89/20/
1 20 QC		Memo		0.00				(24)) 		9-89 4/0 8/12

Quality Control

DQA:			Date:		· · · · · · · · · · · · · · · · · · ·								`	
					WORK ORDER NON-CONFORMANCE / UPDATE								AEROSPACE	
QA Closed:			Date:			· · · · · · · · · · · · · · · · · · ·				V	ork Order up	odate only		
Work Orde						DISPOSITION	5			AGAINST D	EPARTMENT	/PROCESS		
WOIK OIGE	-	·				Rework	1		Skid-tube	Crosstube	٦	Water Jet		Engineering
Part N	lo.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	ヿ	Quality
, u.c.	••••					Use-as-is	1		noforming	Finishing		re/Packaging		Other
NCR N	lo.					Suspected Unapproved	1 1		Composite	Supplier				
Root					Desci	ription of work order update		nitial	Acti	on	Sign &	,		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	Verification		QC Inspector
Design														
Doc/Data	Щ													
Equip/Tooling														
Handling/Pre														•
Material														
Operator		•												
Offset/Setup	\Box													
Process	\vdash								1					
Supplier	-											·		
Training														
Transport Unapproved	Н												Ì	
Oriapproved		7,411	<u>. </u>	<u> </u>	<u> </u>		FΔI	UIT CA	TEGORY			!		
Landi	ng G	iear `			-	General		<u> </u>						7 2 11
	_	Bending				Bend]Folio/F	rogram	Γ	Outside Dim	nensions		Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	\prod_{i}	Set-up
		Cracks				Broken/Damage/Defect	\vdash	Hardwa	are		Part Incorre	ci		Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Un	qualified	Part Lost/M	issing		Weld
		Cuffs				Contamination		Instruct	tions Incomplete/U	Inclear	Part Moved		\ \ '	Wrong Stock Pulled
		Crushing				Countersink		Misalig	gned/off center		Positioned \	Wrong)		
		Heat Trea	at .			Cut Too Short		Mislabe	eled		Power Loss,	'Surge		Other
		Inspectio	n Strip in	Tube		Drawing		Misrea	d	•				
		Marks/Ch	natter			Drill Holes		Off-set			w. · · ·			
		Turning S	equence			Finish		4	Calibration					
		Wave/Tw	ist in Tub	oe .		Fit/Function		Out of	Sequence					

Work Orde May-06-14 8:08		18984					Page 2					
Item ID: Revision ID:	D3546-1		4	Accept	*N900	<u>04</u> 0	1100)* ፡	Setup Sta		JS1*	=
Item Name:	Clip								Sto)b * 	152*	
Start Date:	5/05/14	Start Qty: 8.00	*8*		Cust Item 1	ID:						
Required Date: Reference:	5/05/14	Req'd Qty: 8.00	*8*		Customer:							
Approvals:	Process P	lan:	Date:	Tooling:	D	ate:	_	I	Run Sta	^ \	JR1*	
	QC:		Date:	SPC (Y/N):	D	ate:			Sto	, *V	JR2 *	
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Numbe		- !
130 Brake NC		NC BRAKE		0.00			Das 30	24				N
Brake NC		Memo Form as per	Dwg D3546	0.00			9-8 9	·			,	
140		QC5- Inspect part comple	eteness to step on W/O	0.00							DAS DAS	
140 QC Quality Control		Мето		0.00				24		_	c/. 70	3 9 14
Quality Control												
150 *150*		Identify as per dwg & Sto	ock Location: 57049	0.00				24		AS 28 -89	AUG 2 7 2014	
Packaging		Memo		0.00				<u>~ ~ ~ , </u>	<u>^</u>			

Memo

Packaging

DQA:			Date:			WORK ORDER NON-CONFORMANCE / UPDATE								
QA Closed:			Date:			WORK ORDER HOR			(WIAITCE / C		ork Order up	date only		
Work Orde	ar.					DISPOSITION				AGAINST D	PARTMENT	PROCESS		
Part N	-					Rework Scrap		Machining Small Fab		—	⊣	Water Jet d. Eng. Coor.	Engineering Quality	
NCR N	NCR No.				Use-as-is The Suspected Unapproved		Thern	Thermoforming Finishing Large Fab Composite			e/Packaging Supplier	Other		
Root					Desci	ription of work order update	ı	nitial	Ad	ction	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector	
Design														
Doc/Data														
Equip/Tooling														
Handling/Pre														
Material														
Operator														
Offset/Setup														
Process														
Supplier														
Training														
Transport			1											
Unapproved														
							FAI	JLT CA	regory					
Landi	ng G	iear				General		_			_	,	_	
		Bending				Bend		Folio/F	rogram		Outside Dim	ensions	Pressure/Forced	
		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up	
6.54	· ji	Cracks				Broken/Damage/Defect		Hardwa	ire		Part Incorred	ાં	Temperature/Cure	
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/l	Jnqualified	Part Lost/Mi	ssing	Weld	
		Cuffs				Contamination		Instruct	ions Incomplete,	/Unclear	Part Moved		Wrong Stock Pulled	
	F-1		Countersink		Misalig	ned/off center	· . ·	Positioned V	Vrong					
		Cut Too Short		Mislabe	eled	Γ	Power Loss/	Surge	Other					
			Drawing		Misread	d	_	_						
		Marks/Ch	-			Drill Holes		Off-set						
	\vdash	Turning S				Finish		Out of	Calibration					
	Wave/Twist in Tube			Fit/Function	Out of Sequence									

Work Ord <i>May-06-14 8:</i>		18984		*118				Page 3				
Item ID: Revision ID: Item Name: Start Date: Required Date	D3546-1 Clip 5/05/14 e: 5/05/14	Start Qty: 8.00 Req'd Qty: 8.00	* <u>8</u> * *8*	Accept	*N900 Cust Item 1 Customer:	īD:	100)* 5	Setup Sta		S1* S2*	
Approvals: Process Plan: QC:		lan:	Date:	Tooling: SPC (Y/N):		ate:		F	tun Sta Sto	P	*NR1* *NR2*	
Sequence ID/ Work Center 160 *160* QC Quality Control	ID	Operation Description QC21- Final Inspection Memo	Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty		Reject Number	Insp. Stamp	

DQA:			Date:						_				7	TRAC
0.4.611			Data			WORK ORDER NON-	-CC	ONFO	RMANCE / UPDAT		ork Order up	data anku - F	7	AEROSPACE
QA Closed:			Date:							VV	ork Order up	date only		
Work Orde	er:					DISPOSITION			AG	AINST DE	PARTMENT/	PROCESS		
	•					Rework			Skid-tube Cros	sstube		Water Jet	7	Engineering
Part N	lo.					Scrap			—	all Fab	Prod. Eng. Coor.			Quality
	•					Use-as-is			~ 	ishing	├ ──			Other
NCR I	۱o.					Suspected Unapproved			~ —	posite		Supplier		
				i				<u></u>			c: 0			
Root		_			Desci	ription of work order update		nitial	Action		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	+	QC Inspector
Design													ļ	
Doc/Data														
Equip/Tooling														
Handling/Pre														
Material														
Operator														
Offset/Setup														
Process														
Supplier		;					,							
Training														
Transport														
Unapproved			<u> </u>	<u> </u>	<u> </u>									· · · · · · · · · · · · · · · · · · ·
							FAI	ULT CA	regory	4				
Landi	_	l			_	General	_	1			1		- -	
		Bending			<u> </u>	Bend	<u> </u>	4	rogram	<u> </u>	Outside Dim	⊢		ressure/Forced
		Centre No	ot Concer	ntric	_	BOM/Route		Grain		<u> </u>	Over/Under	<u> </u>	_	et-up
	\vdash	Cracks			_	Broken/Damage/Defect	<u> </u>	Hardwa		-	Part Incorred	⊢	-	emperature/Cure
				Burrs	<u> </u>	4 '	ion Incomplete/Unqualifie		Part Lost/Mi	ssing	_	/eld		
	Cuffs			Contamination	<u></u>	4	ions Incomplete/Unclear		Part Moved	L	\^	Vrong Stock Pulled		
	-	Crushing			<u> </u>	Countersink	$ldsymbol{ld}}}}}}$	1	ned/off center	_	Positioned V		_	
	⊢—	Heat Trea				Cut Too Short	$ldsymbol{le}}}}}}$	Mislabe			Power Loss/	Surge	0	ther
		Inspection	n Strip in	Tube		Drawing	<u></u>	Misrea	d					
	Marks/Chatter D			Drill Holes		Off-set				. <u>-</u>				
	Turning Sequence			Finish		Out of	Calibration							
	Wave/Twist in Tube			oe		Fit/Function	1	Out of	Sequence					

Page 1

Work Order ID: 118984

118984

Parent Item:

D3546-1

D3546-1

Parent Item Name: Clip

Start Date: 5/05/14

Required Date: 5/05/14

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP Rev:A New Issue 06-09-27 JLM

IPP Rev:B

	remove finish DD	10.03.29 verific	ed by:EC										
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased	No			100	sf	577.7100	0.04	0.336842			
M304S18 304/316 .050 Sheet	RGA			Location	Į.	<u>Loc (</u>	<u>Qty</u>	Loc Code	** _			46	17/00/11
				MAT019		56	5.71					9-89	
					117188		3		_				
					117766		5		_				
					120604		5		_				
					122325		3						

3

38

39.75

107.71

187.25

174

12

2

10

M128864 MAT020 124029 M126098 M129530

123155

124572

M126647

M128254

M128435

3.8

DQA:			Date:										TRACT
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE				AEROSPACE
QA Closed:			Date:	•						W	ork Order up	date only	
Work Orde	ır.					DISPOSITION			AGAINST	T DE	PARTMENT	/PROCESS	
WOIR OIGC	'' -					Rework			Skid-tube Crosstube	٦	1	Water Jet	Engineering
Part N	lo.					Scrap			Machining Small Fat	-	Pro	d. Eng. Coor.	Quality
	-					Use-as-is			noforming Finishing	ng Rec/Store/Packaging			Other
NCR N	lo.					Suspected Unapproved Large			Large Fab Composite]	Supplier	
Root					Dosc	ription of work order update		nitial	Action		Sign &		
Cause		Date	Step	Qty	Desci	or non-conformance		iief Eng	i		Date	Verification	QC Inspector
Design	\dashv		жер	Qty		of fion-comormance	Cil	ilei Liig	Description		Dute	Vermeation	QC IIISPECTO!
Doc/Data		٧,					Ì						
Equip/Tooling	\neg	*											
Handling/Pre	\dashv	·											
Material	ヿ												
Operator													
Offset/Setup	\exists												
Process	\neg												
Supplier													
Training									·				
Transport													
Unapproved													
							FA	ULT CA	TEGORY				
Landi	ng G	iear				General		-		_	-	_	
		Bending	•			Bend		Folio/F	Program	Ŀ	Outside Dim	ensions	Pressure/Forced
		Centre No	t Concer	ntric	_	BOM/Route		Grain		_	Over/Under	tolerance	Set-up
	-	Cracks				Broken/Damage/Defect		Hardwa	are	\vdash	Part Incorre	·	Temperature/Cure
		Crimp/Kin	k/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqualified	<u> </u>	Part Lost/Mi	ssing	Weld
	_	Cuffs				Contamination	<u> </u>	4	tions Incomplete/Unclear	<u> </u>	Part Moved	L	Wrong Stock Pulled
	-	Crushing				Countersink		•	gned/off center	_	Positioned V		-
	<u> </u>		Cut Too Short		Mislab			Power Loss/	Surge	Other			
		Drawing		Misrea				·					
	 		Drill Holes	<u>_</u>	Off-set								
	Turning Sequence Finish					4	Calibration						
	Wave/Twist in Tube				Fit/Function	Out of Sequence							

DART AEROSPACE LTD	Work Order:	18984
Description: Clip	Part Number:	D3546-1
Inspection Dwg: D3546 Rev: A		Page 1 of 1

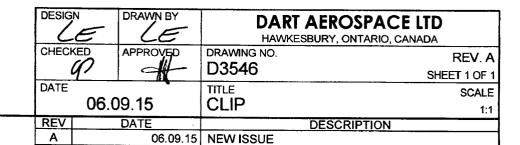
	FIRS	ST ARTICLE	INSPEC	TION CH	ECKLIST	
		X First A	rticle [Prof	totype	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
7.05	+/-0.030	7.04	V		U-5km-01	
0.500	+/-0.010	0.566	V		0 3 201 01	
0.75	+/-0.030	0.75	V	·-w.		
0.375	+/-0.010	0.375	1/			
0.050	+/-0.010	0.698	/			
Ø0.344	+0.006/-0.001	6.398	V			
				40		
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			-			
	,			. 11.1		
	DAS	·		_		
	46					
Measured by:	DAS 46 9-89	Audited by	': 9 <u>-</u> 8		Prototype Approv	val: N/A
Date:	14/08/11	Date	: 14-8	7-12	Da	ite: N/A

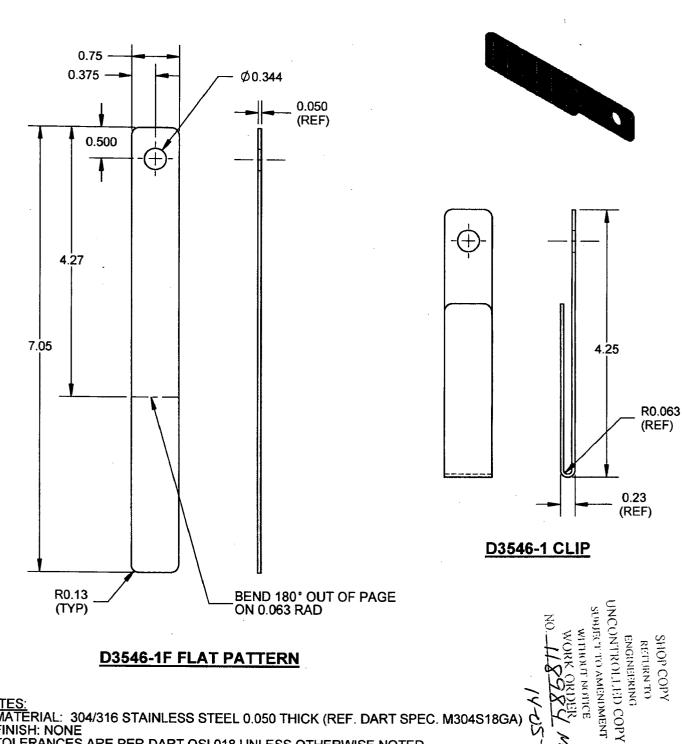
Revised by Approved

H:\FORMS\Quality	Assurance\approved	OALEAL TOUR
TI. IF OR WIS IQUALITY	Assurance\approved	QA\FAI revD

DateChange07.04.02New Issue

Rev





D3546-1F FLAT PATTERN

NOTES 1) MATERIAL: 304/316 STAINLESS STEEL 0.050 THICK (REF. DART SPEC. M304S18GA)

2) FINISH: NONE

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

5) BREAK ALL SHARP EDGES TO 0.010 MAX

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